

Date: Wednesday, 9/12/2007 12:16:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 34640	
Estimate Number : 11314	
P.O. Number : N/A	Part Number : D34571
This Issue : 9/12/2007 S.O. No. : N/A	Drawing Number : D3457 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34013	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 9/30/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 50 Um: 20 Each
Comment : Est. A 05.10.03 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MDELINR1000	Delrin Round Bar 1"
-----	-------------	---------------------



Comment: Qty.: 0.0218 f(s)/Unit Total : 0.6552 f(s)

Delrin Round Bar 1"

Material: Delrin Round Bar Ø1.000

(M-DELIN-R1.000)

Batch: M 104346

Identify for D3457-1

1.15'

20 07/09/13

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA589 Rev: A & Dwg D3457 Rev: A

20 07/09/13

(50)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment:

Machine as per Folio FA589 Rev: AA & Dwg D3457 Rev: A

J.L 07/09/19

46

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2

J.L 07/09/19

(46)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.P 07/09/19

(46)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/19	3	- 2 part lifted during machining - 2 part chamfer was too deep causing gauges in part	<i>[Signature]</i> 07/09/19	scrap / No replace	JL 07/09/19	<i>[Signature]</i> 07/09/19	<i>[Signature]</i> 07/09/19	<i>[Signature]</i> 07/09/19

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:16:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 34640

Part Number: D34571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

J.L. 07/09/19

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

[Signature] 07/09/20 (46)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

[Signature] 07/09/20 (46)

Job Completion



U. 07-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

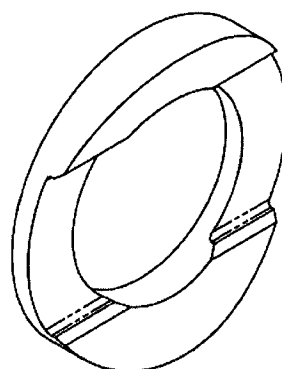
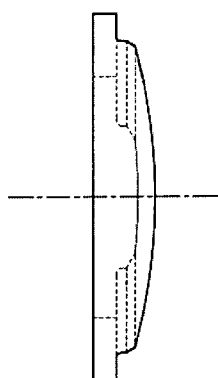
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

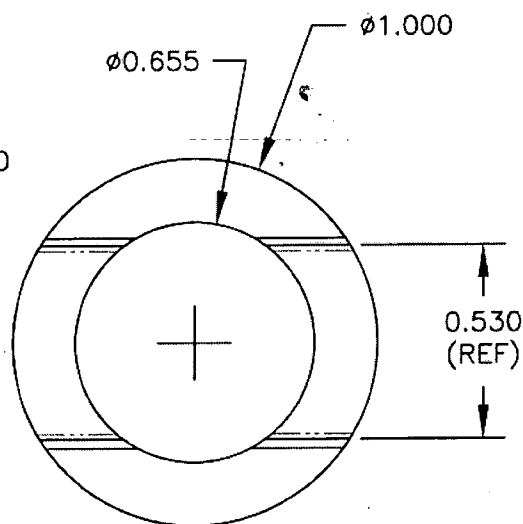
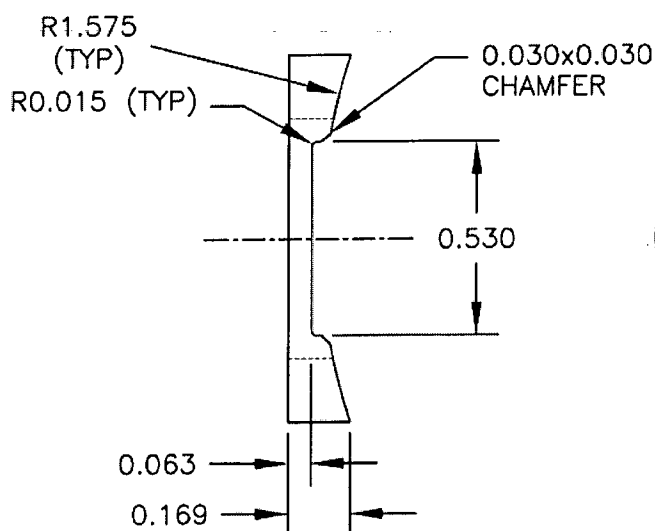


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

RELEASED
05.09.06



ISOMETRIC DETAIL



D3457-1 WASHER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34640

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

